



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

5107799

D206-547-043
Job Sheet 163776



Part No: D206-547-043

Job Qty: 1 ea

Part Name: Console High Slope



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No: RA112547

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D206-547 REV F IPP Rev: I 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/31/17	0.00	0.00	Start Up Small Fab-1		
110	Small Fab	1 pcs		10/31/17	0.00	0.00	Small Fab-1 N/A		
120	QC	1 pcs		10/31/17	0.00	0.00	QC5		DAS 18-0622
200	Packaging	1 pcs		10/31/17	0.00	0.00	Packaging3-1	6	SEP 17 2018
210	QC21-FG	1 Ea		10/31/17	0.00	0.00	QC21	9-89	SEP 17 2018

Part Op 110 - 1-Grind weld relief chamfer as per Dwg D206-547 2-Rivet extrusion to sides as per Dwg D206-547 using Rivet
Descriptions: MS20470AD3-4

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D206-547-043 B163776		1 Ea (1 ea)	90-Start up Operation	3000004

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D206-547-043 B163776	1	1	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

Work Order ID 163776

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163776

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Item ID: D206-547-043

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Console High Slope

Start Date: 7/11/2017 Start Qty: 1.00

1

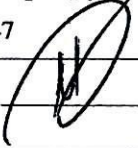
Cust Item ID:

Required Date: 7/12/2017 Req'd Qty: 1.00

1

Customer: CROTO01

Reference: RMA RA112547

Approvals: Process Plan: 

Date: JUL 21 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D206-547

Rev F

110 QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

-Inspect RA112547

-Kit complete but open by customer.

120

Pick Kit

0.00

120

Packaging

Memo

0.00

Packaging

-Make sure kit is complete

-Repackage as per PPP.

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.00

Quality Control

DAS
9
9-89

① 17-03-03

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 7/11/2017 **Start Qty:** 1.00 *** 1 ***

Cust Item ID:

Required Date: 7/12/2017 **Req'd Qty:** 1.00 * 1 *

Customer: CROTO01

Reference: RMA RA112547

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140	Identify as per dwg & Stock Location:	0.00
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140

Packaging	Memo	0.00
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Packaging	-Stock with new batch number at Rev. F. Add new labels.
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150	QC21- Final Inspection - Work Order Release	0.00
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150

QC	Memo	0.00
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Quality Control

Picklist Print

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Work Order ID: 163776

163776

Parent Item: D206-547-043

D206-547-043

Parent Item Name: Console High Slope

Start Date: 7/11/2017

Required Date: 7/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I06-01-05 Removed Packing Kit JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-547-043		Manufactured	No				Each	0.0000		1			
D206-547-043													
Console High Slope													

B131764

**
JUL 21 2017

Inspection Sheet Complete **RA112547**

Customer QA Ref #

0

Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order instructions
D206-547-043	B131764	1	☒ Yes	☒ Yes	☐ Yes	☒ Yes	STOCK	163776	Qty one receive only Kit complete but open by customer. Repackage as per PPP. Make sure kit is complete Stock with new batch number at Rev. F. Add new labels.
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			

QC Approval: P.D.

Date: 8-Jul-17

Item ID: D206-547-043

Status	Item ID	Rev	Name	Start Date	Stop Date	Quantity	Unit	Sec	Sort	is	Off	stan	Type	Per	Orch	to	Win	ore	Coat	Last M	Add Date
	MS20470AD3-4		Rivet, Universal Head	1/1/2008		20.0	Ea	100	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	MS20470AD3-3		RIVET, UNIVERSAL HEAD	1/1/2008		8.0	Ea	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	D2607		Bracket, 206 Console	12/5/2009		1.0	Ea	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	D2606		Console Bracket, 206/407 Console	12/5/2009		1.0	Ea	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	D2602-2		Console Side, 206 Console	12/5/2009		1.0	Ea	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	D2602-1		Console Side, 206 Console	12/5/2009		1.0	Ea	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...
	D2024		Extrusion (\$ per foot)	12/5/2009		3.4	f	110	0	0	MRP	☐	☐	☐						12/5/2...	12/5/2...